

# Work Order ID 78721

**\*78721\***

Page 1

January-13-12 7:09:04 AM

Item ID: D3140-105 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Doubler  
 Start Date: 12/01/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 26/01/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3140	Rev F

100 FLOW WATER JET 0.00  
**\*100\***  
 Waterjet Memo 0.00 4 0 Jm 12-8-18  
 FLOW CNC Waterjet 1-Cut as per Dwg D3140 Dwg Rev: F Prog Rev: F 2-  
 2024 .032 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\***  
 QC Memo 0.00 4 0 Jm 12-8-18  
 Quality Control

120 QC8- Inspect parts - second check 0.00  
**\*120\***  
 QC Memo 0.00 4 0 Jm 12-8-18  
 Quality Control

**DAS**  
**16**  
**12/02/12**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 78721**

January-13-12 7:09:04 AM

**\*78721\***

Page 3

Item ID: D3140-105 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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Item Name: Doubler  
Start Date: 12/01/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 26/01/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		12/6/12		(44)			
170 <b>*170*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				4	26	12-8-21	
180 <b>*180*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				4	0	12-8-21	

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 78721****\*78721\***

Page 4

January-13-12 7:09:04 AM

Item ID: D3140-105

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Doubler

Start Date: 12/01/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg &amp; Stock Location:

028

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

ML3 12/08/23U 12.08.23

W/O:		WORK ORDER CHANGES					
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# Picklist Print

January-13-12 7:09:09 AM

Page 1

Work Order ID: 78721

**\*78721\***

Parent Item: D3140-105

**\*D3140-105\***

Parent Item Name: Doubler

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 4.00

Required Qty: 4.00

**Comments:**

IPP Rev:A New Issue 06-02-08 JLM  
 IPP Rev B New dwg rev. ecn781 06.04.18 EC  
 IPP rev.C added scuffing NCR 061 EC  
 IPP Rev:D As per ECN #829 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.032

Purchased

No

100

sf

106.7000

0.055

~~0.231579~~

**\*\***

**0.25**

**\*M2024T3S 032\***

2024-T3 .032 sheet

Jm 12-8-18

Location

Loc Qty

Loc Code

MAT022

106.7

118243

30.7

118523

76

**121309**

**121309**

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**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

SHOP COPY

RETURN TO

DESIGN OFFICE

UNCONTROLLED COPY

SUBMITTED FOR REVIEW

WORK ORDER

NO. 78721 M.L.J  
12/01/13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND  
ALODINE PER DART QSI 005 4.1

F

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12821

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

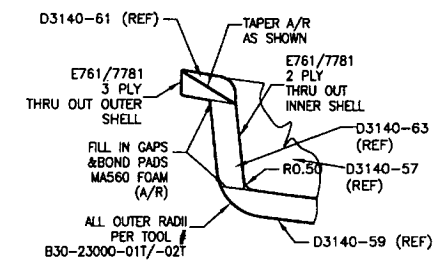
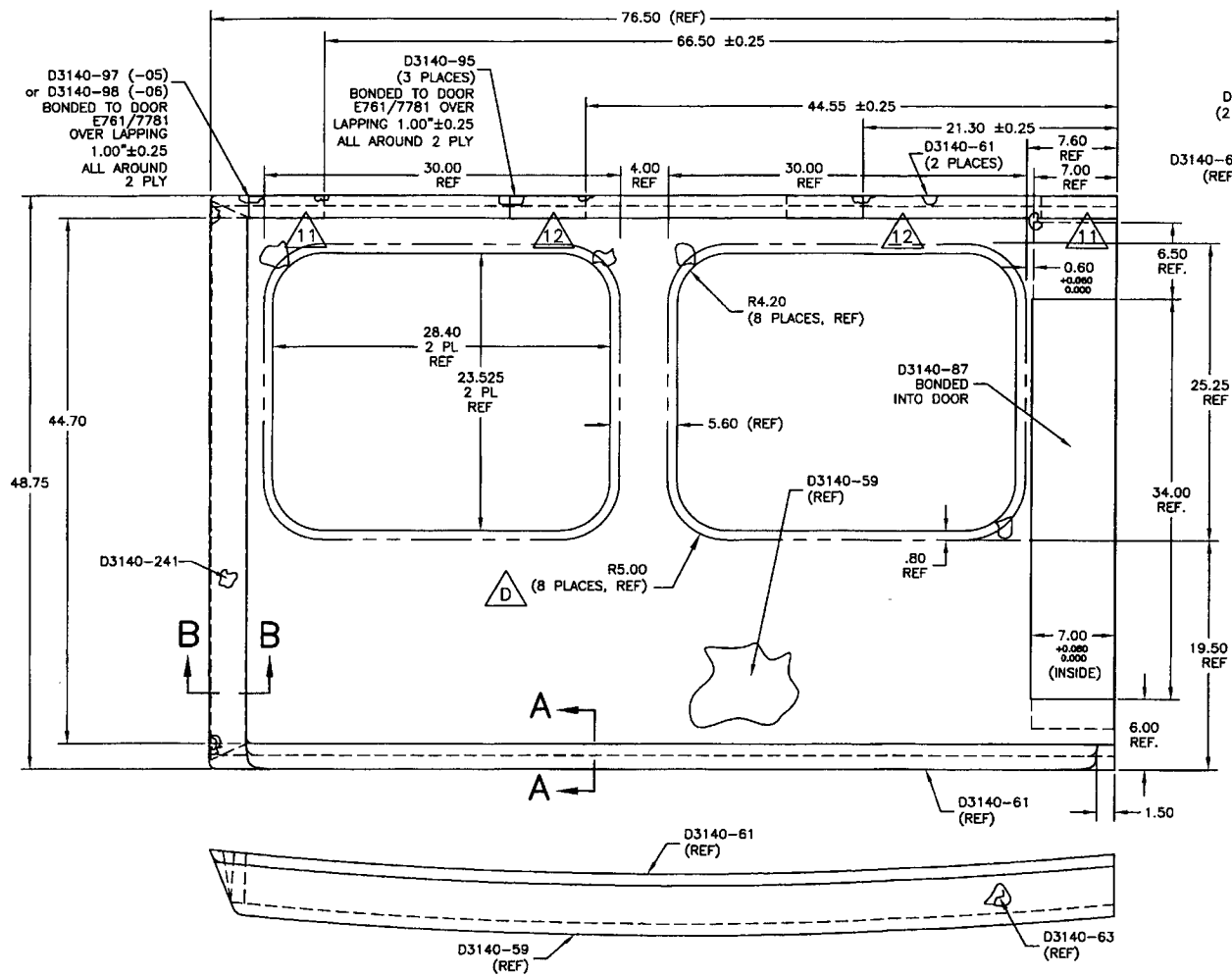
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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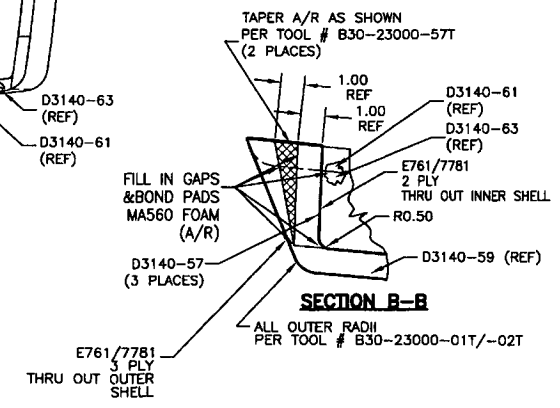
**NOTE:** Date & initial all entries

70721



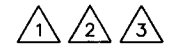
SECTION A-A

RELEASED  
06.11.17



SECTION B-B

**D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)**  
**D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)**  
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)



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DESIGN 4	DRAWN BY CB	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3140	REV. F SHEET 3 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

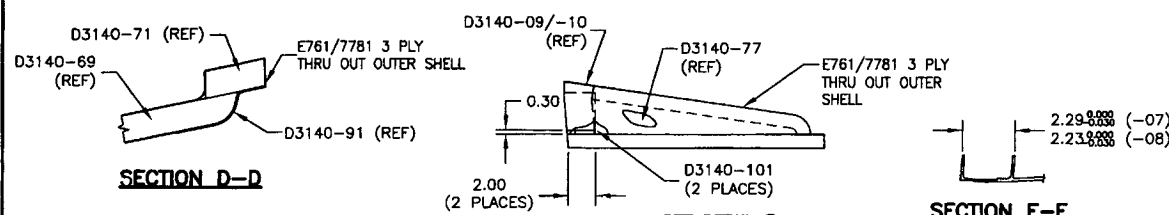
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

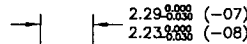
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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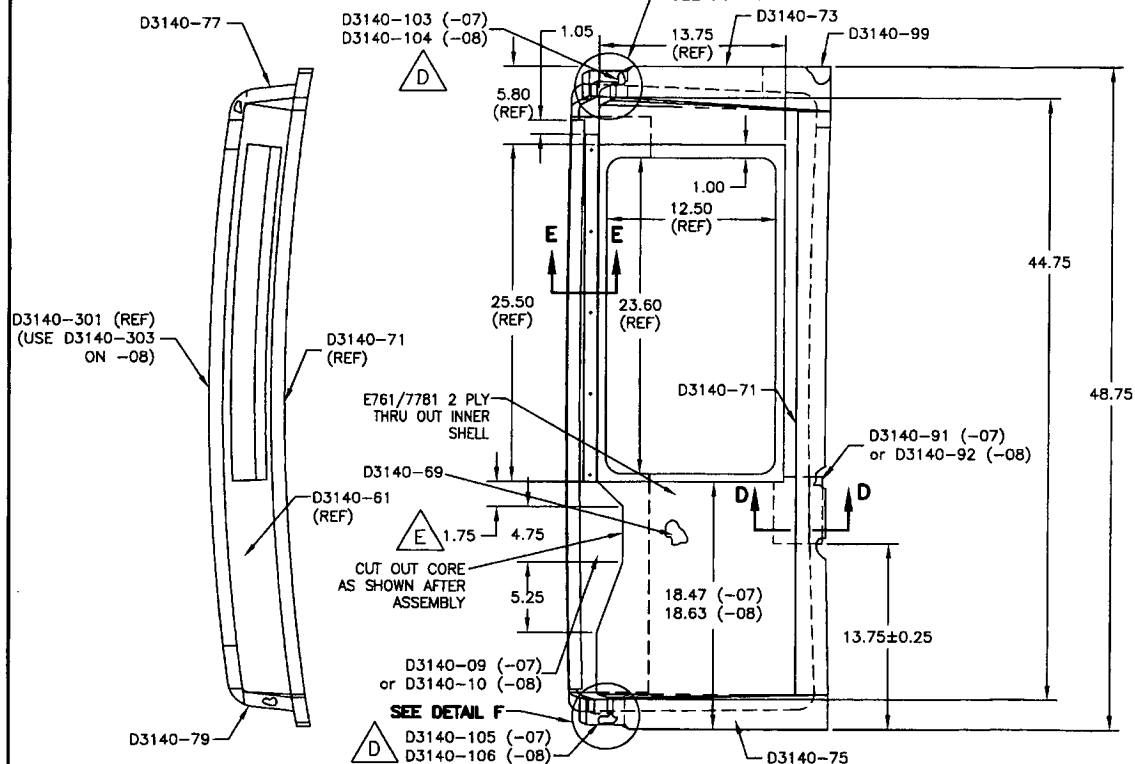




**SECTION D-D**



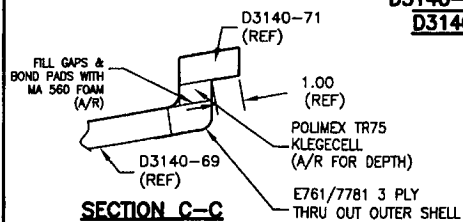
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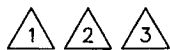
**D3140-07 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-07)**

D3140-08 (OPPOSITE, REPLACES PREMIER P/N B30-23000-08)

(WINDOW TO BE LOCATED BY TOOL B30-23000-03T/-04T)

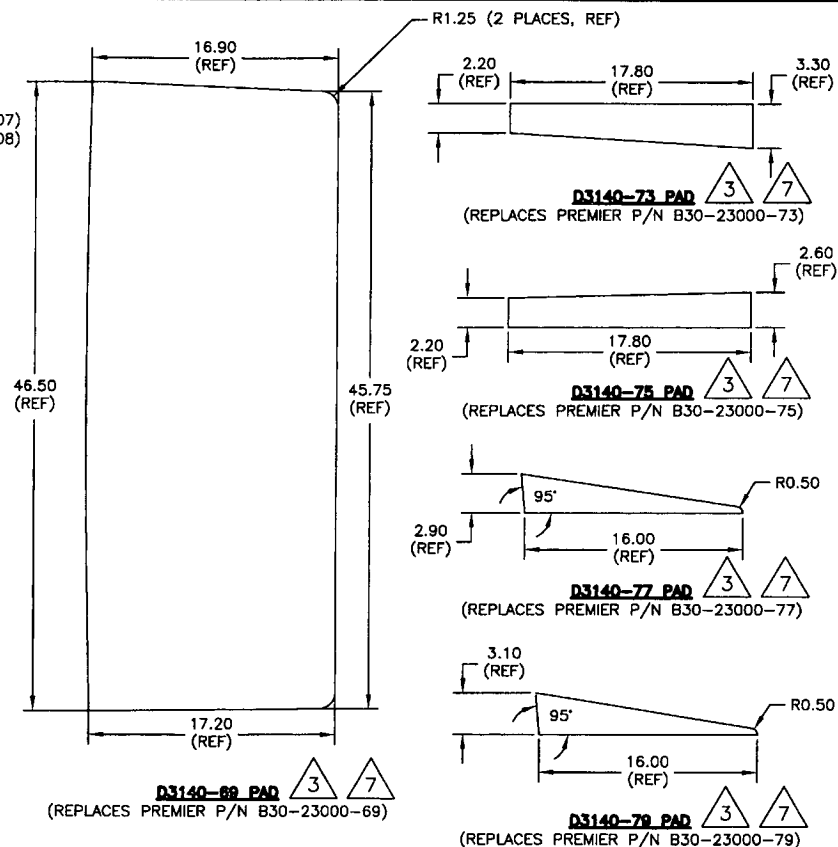
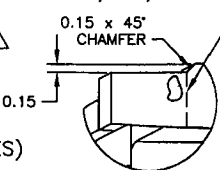


**SECTION C-C**



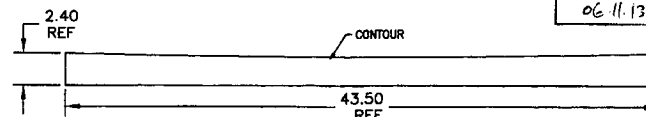
### DETAIL E

(TYPICAL 2 PLACES)



RELEASED

06.11.13



D3140-71 PAD

(REPLACES PREMIER P/N B30-23000-71)

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DART AEROSPACE LTD.

## DESIGN

9

<div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>CHECKED</b> </div>
---

\_\_\_\_\_

DATE \_\_\_\_\_

DRAWN BY

CB

APPROVED

\_\_\_\_\_

\_\_\_\_\_

**DART**

	DRAWING NO.
--	-------------

D3140

TITLE	
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**DART AEROSPACE LTD.**  
HAWKESBURY, ONTARIO, CANADA

REV. 8

T 4 OF 7

SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

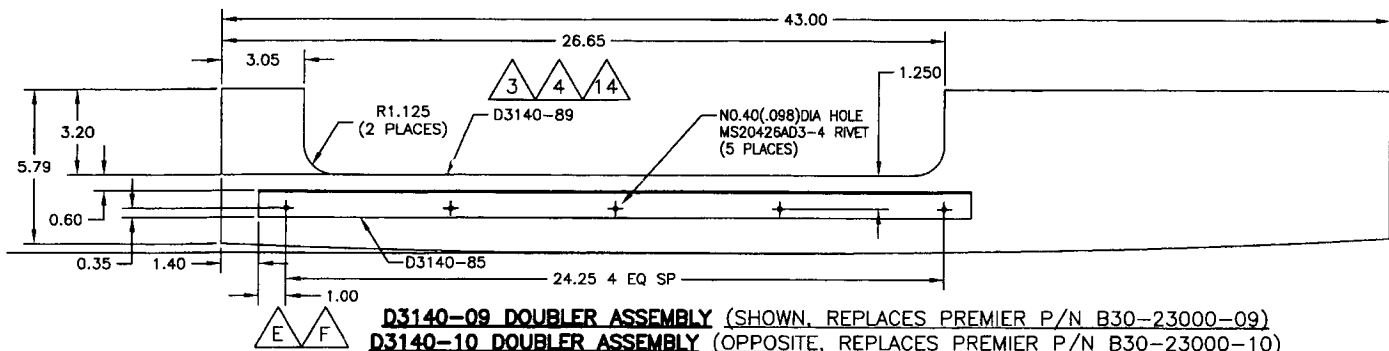
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

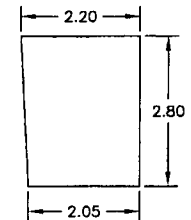
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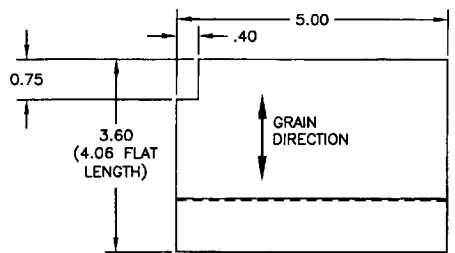
78721



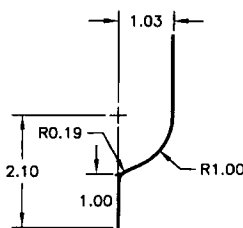
**D3140-09 DOUBLER ASSEMBLY** (SHOWN, REPLACES PREMIER P/N B30-23000-09)  
**D3140-10 DOUBLER ASSEMBLY** (OPPOSITE, REPLACES PREMIER P/N B30-23000-10)



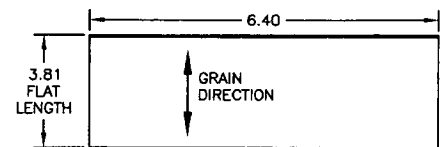
**D3140-101 DOUBLER** (REPLACES PREMIER P/N B30-23000-101)



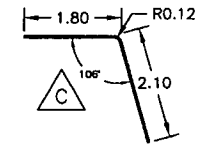
**D3140-91F FLAT PATTERN**  
 (USE TO MAKE D3140-91/-92 DOUBLERS)



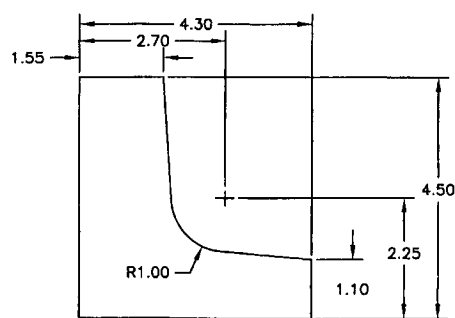
**D3140-92 DOUBLER** (SHOWN, REPLACES PREMIER P/N B30-23000-92)  
**D3140-91 DOUBLER** (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



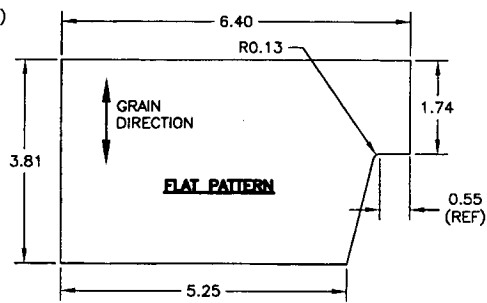
**D3140-95 DOUBLER** (REPLACES PREMIER P/N B30-23000-95)



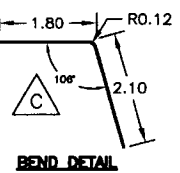
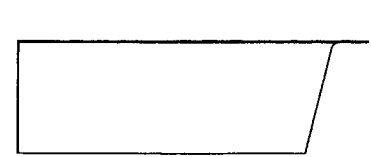
RELEASED  
 06.11.13



**D3140-99 DOUBLER** (REPLACES PREMIER P/N B30-23000-99)



**D3140-97F FLAT PATTERN**  
 (USE TO MAKE D3140-97/-98 DOUBLERS)



**D3140-97 DOUBLER** (SHOWN, REPLACES PREMIER P/N B30-23000-97)  
**D3140-98 DOUBLER** (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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DESIGN #	DRAWN BY CB	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED JH	APPROVED JH	DRAWING NO. D3140	REV. F SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE	NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

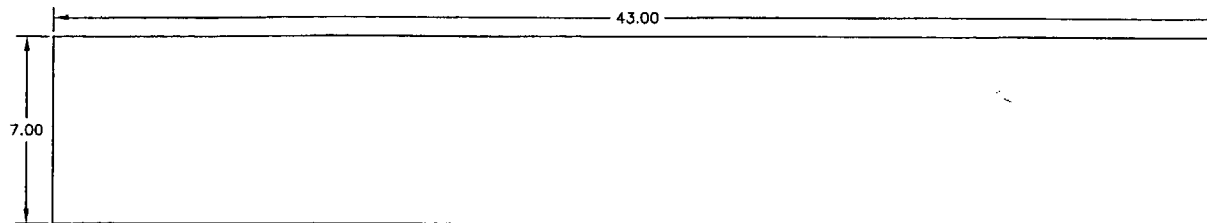
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

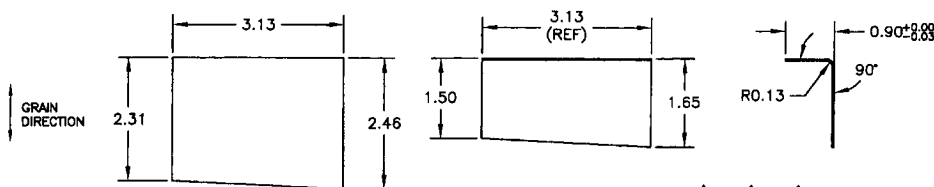
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78721

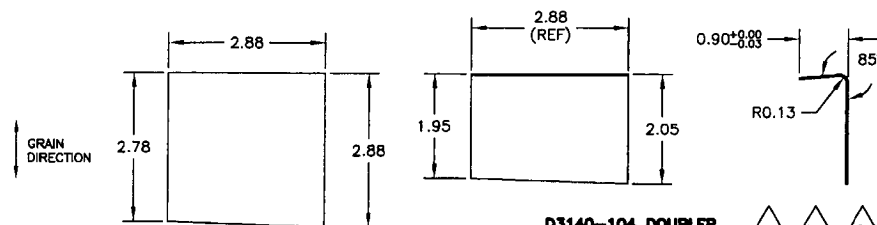
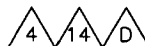


**D3140-87 DOUBLER**   
(REPLACES PREMIER P/N B30-23000-87)



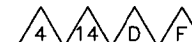
**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)

**D3140-105 DOUBLER**  
(REF)  
D3140-106 OPPOSITE

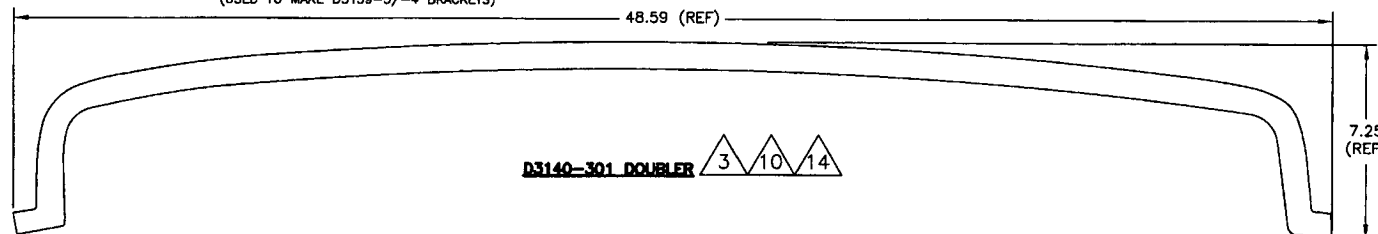


**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)

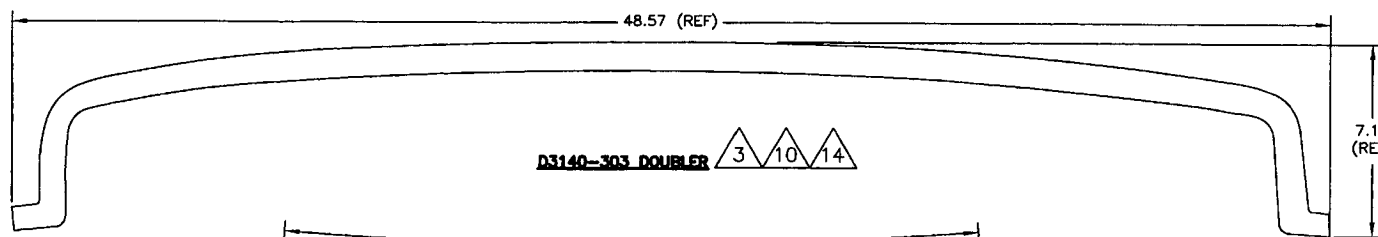
**D3140-104 DOUBLER**  
D3140-103 OPPOSITE



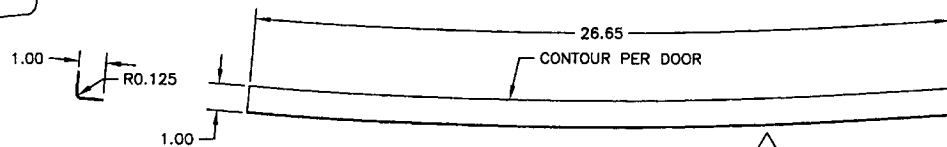
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**D3140-301 DOUBLER**



**D3140-303 DOUBLER**



**D3140-85 ANGLE**   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

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DESIGN <b>4</b>	DRAWN BY <b>CB</b>	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA	REV. F
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	SHEET 6 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

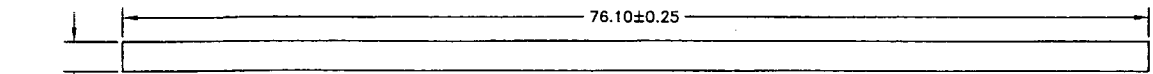
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

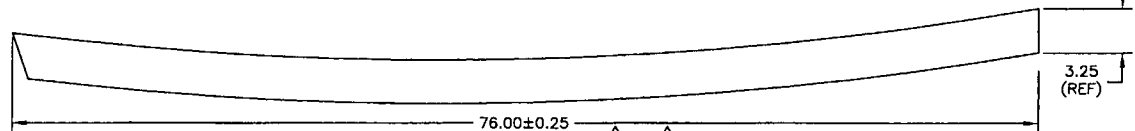
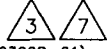
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

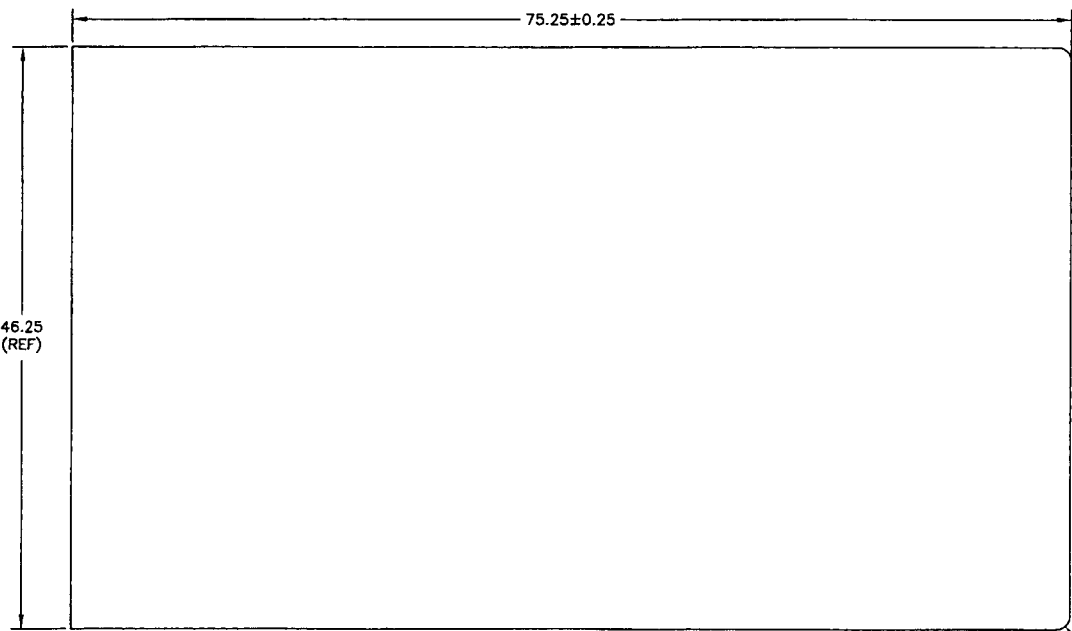
70721



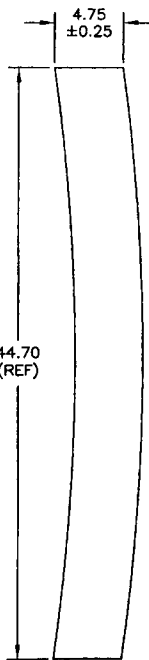
**D3140-61 PAD**  
(REPLACES PREMIER P/N B30-23000-61)



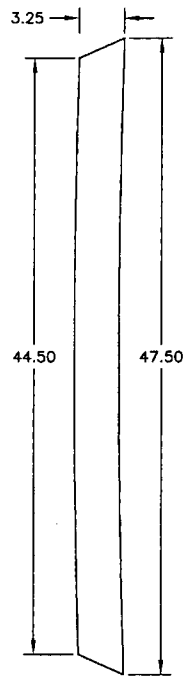
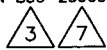
**D3140-63 PAD**  
(REPLACES PREMIER P/N B30-23000-63)



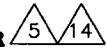
**D3140-59 PAD**  
(REPLACES PREMIER P/N B30-23000-59)



**D3140-57 PAD**  
(REPLACES PREMIER P/N B30-23000-57)



**D3140-241 DOUBLER**  
(REPLACES PREMIER P/N B30-23000-241)



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(2 PLACES, REF)

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		DATE		DRAWING NO.	REV. F
		06.10.06		D3140	SHEET 7 OF 7
				TITLE	SCALE
				DOOR	NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





